~~Summary~~ Abstract

A process for hobble or jerk or limp lathing, and a preferred process applications, are proposed for the cutting of workpieces with non-circular or discontinuous contours on programmable lathes, in which the use and combination of a special program e.g. of thread cycles and jerk values for the diameter and/or the longitudinal axis or the pitch, the angle of the spindle, in option of a pilgrim-step technique and interleaved machining sequences opens up virtually infinite possibilities.

The preferred applications of the process allow special threads to be cut on screw-in bodies, e.g. screw-in artificial hip joint sockets and bone screws for example with neutral or virtually any angle of pinch or relief of the thread blade as well as e.g. internal and external contours on workpieces for circular wedge connections.

At the same time and together with the invention a particularly beneficial hip joint socket is presented comprising so-called screw or threaded surfaces.